

D206-628-034

Dart Aerospace Ltd.

Date: Wednesday, 13/05/2009 11:28:45 AM
 User: Julie Dawson

Process Sheet

| | | | | | | | |
|-----------------------|---------------------------------------|----------|----------------|------------------|----------------------------------|------|------------|
| Customer | CU-DAR001 Dart Helicopters Services | | | Drawing Name | FLOAT STEP ASSEMBLY RH (206/407) | | |
| Job Number | 47933A | | | Part Number | D2842042 | | |
| Estimate Number | 11775 | | | Drawing Number | D2842 REV B | | |
| P.O. Number | : | | | Project Number | N/A | | |
| This Issue | 13/05/2009 | S.O. No. | : | Drawing Revision | B | | |
| Prsht Rev. | NC | | | Material | : | | |
| First Issue | / / | Type | LARGE FAB ASSY | Due Date | 29/05/2009 | Qty: | 8 Um: Each |
| Previous Run | 46698A | | | | | | |
| Written By | : | | | | | | |
| Checked & Approved By | <u>JL 09.05.13</u> | | | | | | |
| Comment | Est Rev:D As Per Ecn 766 06-01-06 JLM | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| 1.0 | D2622120C | Step Extrusion | |
| | | | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>B45494</u> | |
| | | Check Material for any Dents or Defects | |
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 | |
| | | | |
| | | Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 3-Deburr and bevel ends for welding | |
| 3.0 | D2734 | Step End Plate | |
| | | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>343535</u> | |

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 47933A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 D34591

Float Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

plate

Batch: *346864=1 346988=9*

14-09-05-20

8

5.0 D34593

Float Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

plate

Batch: *346866=6 346988=10*

14-09-05-20

8

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842

A/R AL Rod Batch: *011/0130*

~~011/0130~~ *m110972*

14-09-05-20

8

2-Grind end cap weld flush

SAD 09-05-25

8

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

P 09.05-26 ⑤

8

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09.05.26 +8.41

8

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

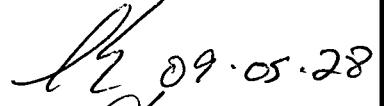
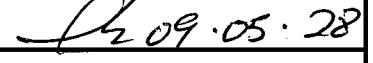
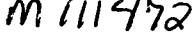
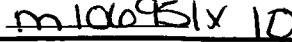
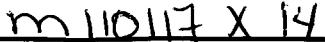
Chemical Conversion Coat as per QSI 005 4.1

SAD 09-05-26 18

8

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Process Sheet

| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: FLOAT STEP ASSEMBLY RH (206/407) |
|----------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Job Number: 47933A | | Part Number: D2842042 |
| Job Number: | | |
| | | |
| Seq. #: | Machine Or Operation: | Description : |
| 10.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION    |
| Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION | | M-A 09/05/27 |
| 11.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1   |
| Comment: LARGE FABRICATION RESOURCE 1 | | |
| 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. A/R AL Rod Batch: M110130 | | SAD 09-05-27    |
| 2-Grind end cap weld flush. | | |
| 12.0 | QC9 | VISUAL WELDING INSPECTION   |
| Comment: VISUAL WELDING INSPECTION | | RE 09-05-29 |
| 13.0 | QC5 | INSPECT WORK TO CURRENT STEP   |
| Comment: INSPECT WORK TO CURRENT STEP | | S 09/05/29 (X824) |
| 14.0 | POWDER COATING | POWDER COATING   |
| Comment: POWDER COATING Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 | | Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 09/06/01   |
| START TIME: 11:50 OVEN TEMPERATURE: 320° FINISH TIME: 12:20 | | |
| 15.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION   |
| Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION | | JL / umd 09/06/02  |
| 16.0 | NAS1329C3KB130 | insert   |
| Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s) Insert Pick: Qty Part Number Description Batch 3 NAS1329C3KB130Insert | | umd SAD   |

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Process Sheet

| | | |
|-------------------------------------------------------------------------------------------------------------------------------|-----------------------|------------------------------------------------|
| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: FLOAT STEP ASSEMBLY RH (206/407) |
| Job Number: 47933A | | Part Number: D2842042 |
| Job Number: | | |
| Seq. #: | Machine Or Operation: | Description : |
| 17.0 | MS27039C107 | screw |
| Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s) Pick: Qty Part Number Description Batch | | m 111424 LMP SAD 09-06-03 (8) |
| 18.0 | NAS1515H3L | WASHER |
| Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s) Pick: Qty Part Number Description Batch | | m 111806 LMP SAD 09-06-03 (8) |
| 19.0 | AN960C10L | washer |
| Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s) Pick: Qty Part Number Description Batch | | m 111808 LMP SAD 09-06-03 (8) |
| 20.0 | HAND FINISHING | HAND FINISHING RESOURCE #1 |
| Comment: FINISHING 1 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: m 111803 | | SAD / BL 09-06-3 (8) |
| 21.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| Comment: INSPECT WORK TO CURRENT STEP | | Sot 66103 KERH |
| 22.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PPP 48933 | | J 9/8/10 (8) |

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 47933A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation:

Description :

23.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/10 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | - | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

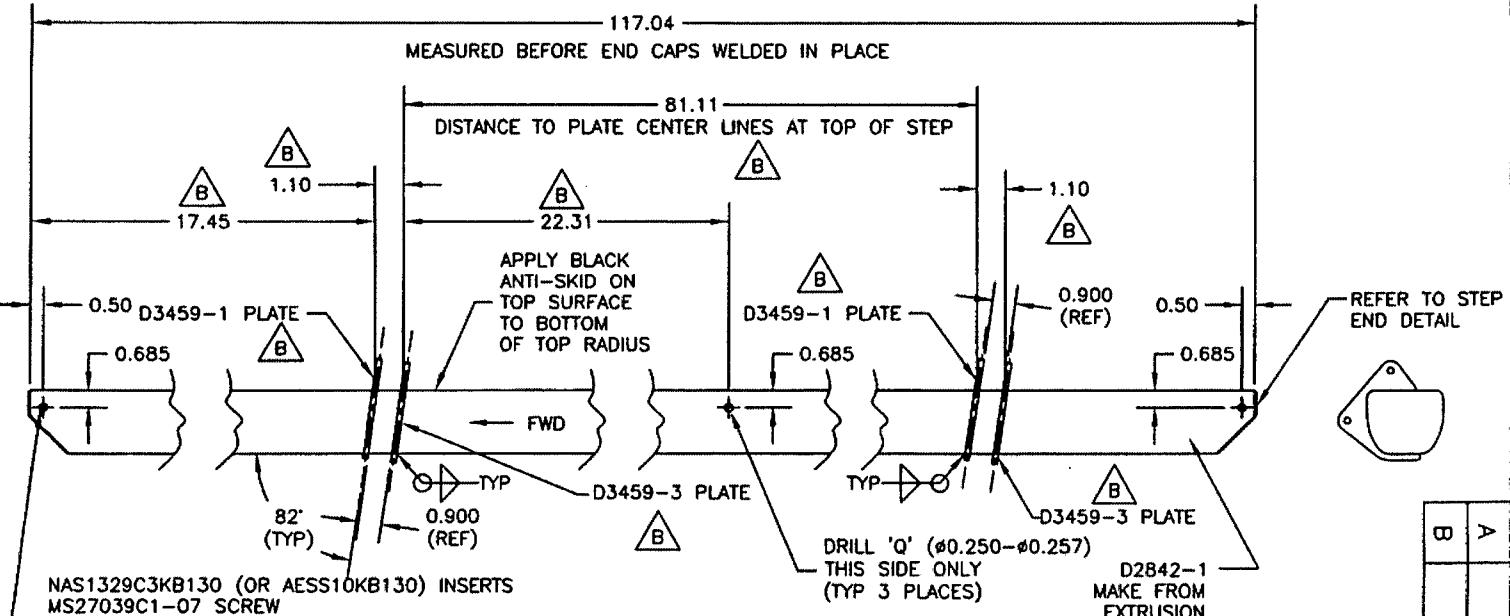
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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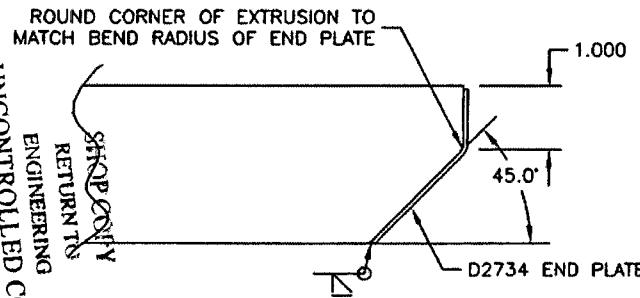
| | |
|--------|----------|
| 5-4-14 | RELEASED |
|--------|----------|



D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

| QTY | OTY | PART NUMBER | DESCRIPTION |
|------|------|------------------------------------|------------------|
| -041 | -042 | | LH STEP ASSEMBLY |
| X | X | D2842-041 | RH STEP ASSEMBLY |
| | | D2842-042 | |
| 1 | 1 | D2622-118 | EXTRUSION |
| 2 | 2 | D2734 | END PLATE |
| 2 | 2 | D3459-1 | PLATE |
| 2 | 2 | D3459-3 | PLATE |
| 3 | 3 | NAS1329C3KB130 (OR AESS10KB130) | INSERT |
| 3 | 3 | MS27039C1-07 | SCREW |
| 3 | 3 | NAS1515H3L | WASHER |
| 3 | 3 | AN960C10L | WASHER |



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

| DESIGN KE | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA |
|-----------|-------------|----------------------------------------------|
| CHECKED | APPROVED | DRAWING NO. |
| | | D2842 |
| DATE | | SHEET 1 OF 1 |
| 05.09.23 | 98.10.13 | SCALE |
| A | | 206L/407 FLOAT STEP ASSEMBLY |
| B | 05.09.23 | NTS |
| | | RE-DESIGN, ADD D3459-1/-3 |